Wednesday, 3/21/2007 1:59:13 PM Date: "User: Kim Johnston **Process Sheet** : CU-DAR001 Dart Helicopters Services **Drawing Name** : GASKET Customer Job Number : 31402 : 12790 **Estimate Number** :NIA : D35533 P.O. Number. Part Number S.O. No. : N/A : 3/21/2007 D3553 REV A **Drawing Number** This Issue : N/A Prsht Rev. Project Number Type : SMALL /MED FAB First Issue **Drawing Revision** Material **Previous Run** : 3/30/2007 Each **Due Date** Qty: 10 Um: Written By Checked & Approved By Comment : Est Rev: A New Issue 07-03-08 ec **Additional Product** Job Number: Seq. #: 4 Machine Or Operation: Description: 1,00 MNEO60S063 NEOPRENE SHEET 0.063 10.00 Comment: Qty.: 1.5225 sf(s) 0.1523 sf(s)/Unit Total: 030403 **NEOPRENE SHEET 0.063** M103104 2.0 WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3553 Dwg Rev: 14 m 070403 2-Deburr if necessary INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 Comment: SECOND CHECK PACKAGING 1 PACKAGING RESOURCE #1 5.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:

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W/O:			WOF	K ORDER CHANGE	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		Description of NC Corrective Action Section B Verification				Verification	A		
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NOTE: Date & initial all entries

Date:

· ~ Wednesday, 3/21/2007 1:59:14 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 31402

Part Number: D35533

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



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Comment: FINAL INSPECTION/W/O RELEASE

07/04/05

Job Completion

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W/O:		WORK ORDER CHANGES								
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3.46 (REF)

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2.71

R0.38 (TYP) 0.22x0.30 R0.37 **OBROUND** (TYP) () (4 PLACES) 3.46 1.96 2.71 (REF) RETURN TO

PENGINEERING
ONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE SHOP COPY WE CARRE D3553-3 GASKET D3553-1/-3 GASKET MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER

R0.38 (TYP)

R0.38

(TYP)

3.50

4.25 (REF)

D3553-1 GASKET

07.01.11 CHECKED B APPROVED 07.01.11 Ð D3553 GASKET DRAWING NO. NEW ISSUE DART AEROSPACE PORT HADLOCK, ₹ USA, SHEET NC. 1 약 1 SCALE 1:2

DATE

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2) FINISH:

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0.22x0.30

OBROUND

(4 PLACES)

R_{0.13} (TYP)

NONE

3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

(REF. DART SPEC M-NEO60-S.063)

5) PART IS SYMMETRICAL ABOUT CENTERLINE

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DART AEROSPACE LTD	Work Order:	31402
Description: GASKet	Part Number:	D3553-3
Inspection Dwg: 1)3553 Rev:A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

		$\sqrt{}$	First Article		Prototy	pe	
	spection Sheet wing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Α	0.2) X 0.30	H-0.030	0.99x030	J		VEIN	
В	3.46	H-0.030	3,46	2		NEWN	
С	2.71	+1-0.030	2.71	\ \		NEVA	
D	1.96	H-0.030	1.96	J		LNRY	
E	5.86	+1-0.030	5.86	J		VerN	
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Revised by

KJ/RF

Approved

New Issue

Change

Date

Rev